

Date: Tuesday, 19/08/2008 11:20:11 AM  
 User: Julie Lecocq

## Process Sheet

C

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350/355 AS X-TUBE AFT  
 Job Number : 41388  
 Estimate Number : 12486  
 P.O. Number :  
 This Issue : 19/08/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D350748201  
 First Issue : / / Type : CROSSTUBES Drawing Number : N/A  
 Previous Run : 40412 Drawing Revision : D  
 Material :  
 Due Date : 05/09/2008 Qty: 1 Um: Each  
 Written By :  
 Checked & Approved By : JUL 08.8.19  
 Comment : Est Rev: A New Issue 06-07-05 JLM  
 Est Rev: B Update qty of MS21042L5 06-09-12 KJ  
 Est Rev C Combined manufacturing 08.04.02 EC verified by:  
 DD  
 Est Rev:D 08-06-24 revD as per dwg DD verified by:EC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD350-748-201 CHG001

8 08/10/08

2.0 D350748241TRN Crosstube Turning Detail



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

CROSSTUBE TURNING DETAIL

batch B401132 DP 8-10-06

3.0 BENDING BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT

DP 8-10-06

4.0 QC15 DIMENSIONAL CHECK OF X-TUBES



Comment: DIMENSIONAL CHECK OF X-TUBES

08.10.07

5.0 CROSSTUBES CROSSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Remove all marks from tube within limits of D350-748-241

2-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs,

Set-up drill table as per QSI 010

2T 08-10-07

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 41388

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Deburr

*AW 8-10-07*

4-Engrave Part # and Batch # as per Dwg D350-748-241 *RT 08-10-07*

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

*5 08/10/07*

7.0

OUTSIDE SERV.10

OUTSIDE SERVICES -skids



Comment: Sub-Contracting OUTSIDE SERVICES

Issue P/O: *7326*

Stress relief at 375° for 5 hours

Magnetic Particle Inspect per ASTM E1444

Cadium Plate per AMS-QQ-P-416B, Class 1, Type 2

Embrittle relief at 375° for 8 hours, Chromate Treat

Possible Supplier: Southwest United Industries

Ensure Certificate of Conformity is attached

*CL 08/10/07*

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

*CL 08/10/07*

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*5 08/10/23*

10.0

SPRAY PAINTING

SPRAY PAINTING



Comment: SPRAY PAINTING

1-Prime inside crosstube as per QSI 005 4.2

2-Paint Outside of Tube as per Dart QSI 005 4.2

*RT 08-10-23*

11.0

QC14

INSPECT SPRAY PAINT



Comment: Inspect Spray Paint

Then, Wrap in plastic bag to protect from scratches

*5 08/10/24*

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 41388

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2856400

Abrasion Strip



Comment: Qty.: 1.2401 f(s)/Unit Total: 1.2401 f(s)

Abrasion Strip 7.10" long x2

Batch: 37667

RT 08-10-27

13.0

ALS41032225

Insert



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Insert

Batch: 100621

RT 08-10-27

14.0

AN960JD10

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Washer

Batch: 109079

RT 08-10-27

15.0

MS2192020

Clamp (per MIL-DTL-8783C)



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Clamp (per MIL-DTL-8783C)

Batch: 107501

RT 08-10-27

16.0

MS27039110

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Screw

Batch: 18836

RT 08-10-27

17.0

CROSTUBES

CROSTUBES RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Install Ground wire Insert, then insert screw and washer

2-Install Abrasion strips as per Dwg D350-748-241 & QSI 035.

3-Install supports Using Dt8876 as per Dwg D350-748-241, Torque to 60-80 IN-LBS

RT 08-10-27

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
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|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 41388

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SS 08/10/28 (X)

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

20.0

D35001

Saddle



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

350 SADDLE

Batch: 35781

SS 08/10/28 (X)

21.0

D35021

Support



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

SUPPORT

Batch: 35783

RT 08-10-27

installed on tube

22.0

D35011

Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

BUSHING

Batch: 35316

SS 08/10/28 (X)

23.0

AN46A

Bolt



Comment: Qty.: 16.0000 Each(s)/Unit Total: 16.0000 Each(s)

Bolt

Batch: M108550

SS 08/10/28 (X)

24.0

AN441A

bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total: 8.0000 Each(s)

bolt

Batch: M109061

SS 08/10/28 (X)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



Date: Tuesday, 19/08/2008 11:20:12 AM  
User: Julie Lecocq

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 41388

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

25.0

AN532A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M109061

SS 08/10/28 (X)

26.0

AN960JD416

Washer



Comment: Qty.: 32.0000 Each(s)/Unit Total : 32.0000 Each(s)

Washer

Batch: M108827

SS 08/10/28 (X)

27.0

AN960JD516

Washer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Washer

Batch: M109059

SS 08/10/28 (X)

28.0

MS21042L4

Nut



Comment: Qty.: 24.0000 Each(s)/Unit Total : 24.0000 Each(s)

Nut

Batch: M108145

SS 08/10/28 (X)

29.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M108827

SS 08/10/28 (X)

30.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

SS 08/10/28 (X)

31.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D350-748-201

Location:

PPP Rev: A

8/10/28

(X) SP

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 350/355 AS X-TUBE AFT

Job Number: 41388

Part Number: D350748201

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

QC21

FINAL INSPECTION/W/O RELEASE



8

Comment: FINAL INSPECTION/W/O RELEASE

Done 10/29

Job Completion



U 08/10/29

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

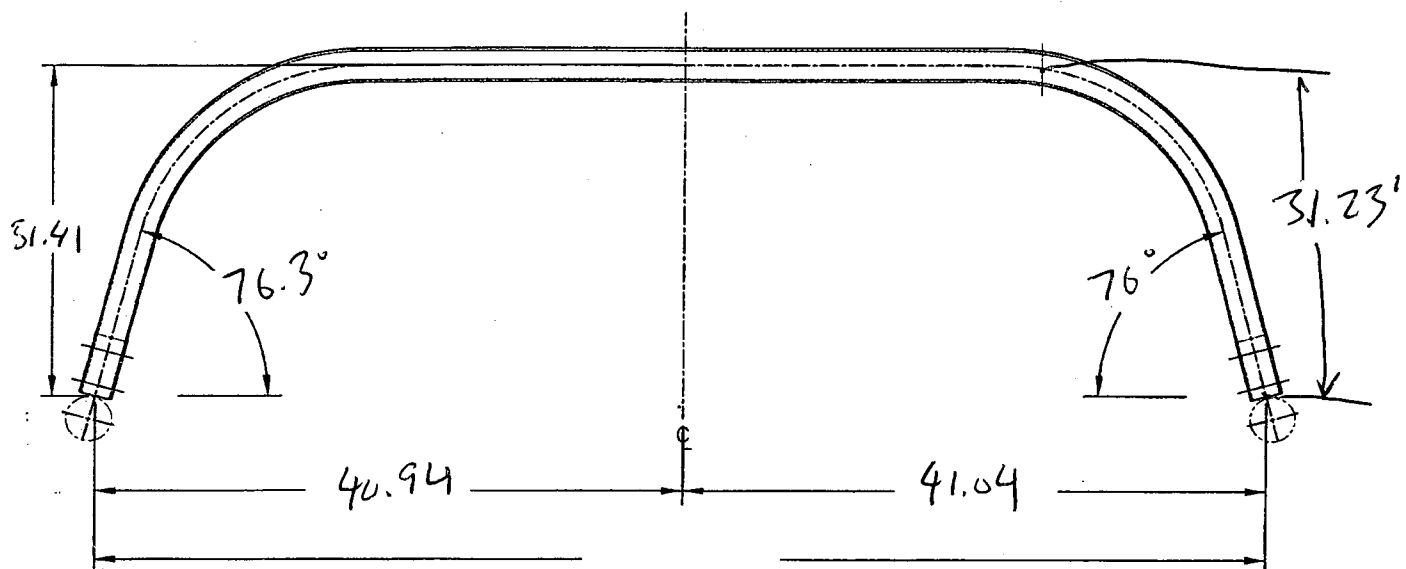
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

|   |  |              |              |
|---|--|--------------|--------------|
| DART AEROSPACE LTD                          |  | Work Order:  | 41388        |
| Description: Crosstube High Aft (AS350/355) |  | Part Number: | D350-748-201 |
| Inspection Dwg: D350-748-241 Rev: D         |  | Page 1 of 1  |              |

| Required Dimension | Min   | Max   |
|--------------------|-------|-------|
| Height             | 31.22 | 31.48 |
| 1/2 Span           | 40.77 | 41.03 |
| Angle              | 75    | 77    |
| Total Span         | 81.54 | 82.06 |



| Comments                           |
|------------------------------------|
| Tube acceptable <i>GP</i> 08.10.07 |
|                                    |
|                                    |

|                 |           |
|-----------------|-----------|
| QC15 Inspection | <i>GP</i> |
| Date            | 08.10.07  |

| Rev | Date     | Change    | Revised by               | Approved           |
|-----|----------|-----------|--------------------------|--------------------|
| A   | 07.02.06 | New Issue | KJ/JM <i>[Signature]</i> | <i>[Signature]</i> |



|                       |                        |  |                        |
|-----------------------|------------------------|--|------------------------|
| DESIGN<br><i>qp</i>   | DRAWN BY<br><i>qp</i>  | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>///</i> | APPROVED<br><i>///</i> | DRAWING NO.<br>D350-748-241                              | REV. D<br>SHEET 1 OF 3 |
| DATE<br>06.10.31      |                        | TITLE<br>CROSSTUBE (AS 350/355 HI AFT)                   | SCALE<br>NTS           |
| A                     | 06.03.31               | NEW ISSUE  |                        |
| B                     | 06.06.30               | ADD D6018-125 & PRIME AND PAINT                          |                        |
| C                     | 06.08.14               | ADD CAD PLATING  |                        |
| D                     | 06.10.31               | MAG. PARTICLE AND CAD PLATE AS MFD.                      |                        |

RELEASED

06.10.31 *///*

| QTY | P/N           | DESCRIPTION                            |
|-----|---------------|--|
| X   | D350-748-241  | CROSSTUBE ASSEMBLY (AS 350/355 HI AFT) |
| 1   | D6018-125     | CROSSTUBE (OR D6015-125)               |
| 2   | D3502-1       | SUPPORT                                |
| 2   | D2856-400-710 | ABRASION STRIP                         |
| 1   | AELS-1032-225 | INSERT                                 |
| 1   | AN960JD10     | WASHER                                 |
| 2   | MS21920-20    | CLAMP (PER DART SPEC. M-MS21920-20)    |
| 1   | MS27039-1-10  | SCREW                                  |

**D350-748-141 CROSSTUBE:**

- 1) MATERIAL: MANUFACTURED FROM D6018-125 OR D6015-125  
FINISHED LENGTH = 122.70±0.06
- 2) MACHINE PER MACHINING DETAIL ON PAGE 3. BLEND OUT ALL EDGES FROM MACHINING LONGITUDINALLY, TRANSITIONS SHOULD BE SMOOTH. NOTE: ALL HOLES ARE DRILLED AFTER BENDING.
- 3) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 4) BEND PROGRESSIVELY WITH A MINIMUM OF 7 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 5) HEAT TREAT TO MIN. 180 KSI PER MIL-T-6736 OR AMS 2759-1C AFTER TURNING
- 6) FINISH: MAGNETIC PARTICLE INSPECT PER DART QSI 038 4.2  
CADMIUM PLATE PER AMS-QQ-P-416B, CLASS 1, TYPE II  
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2  
PAINT OUTSIDE PER DART QSI 005 4.2
- 7) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE. WHEN DRILLING HOLES EXTREME CARE MUST BE TAKEN AND CAREFUL DEBURRING PERFORMED TO ENSURE A CLEAN HOLE WITH NO CRACKING/CHIPPING/GROOVES.
- 8) INSTALL D2856-400-710 ABRASION STRIP WITH A GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D3502-1 SUPPORT, PER QSI 035.
- 9) TORQUE MS21920-20 CLAMPS 60 TO 80 IN-LB
- 10) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 11) ALL DIMENSIONS ARE IN INCHES
- 12) PART IS SYMMETRIC ABOUT CENTERLINE EXCEPT FOR Ø0.297 HOLE.

SHOP COPY

RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
END OF DOCUMENT  
WITHOUT NOTICE  
WORK ORDER

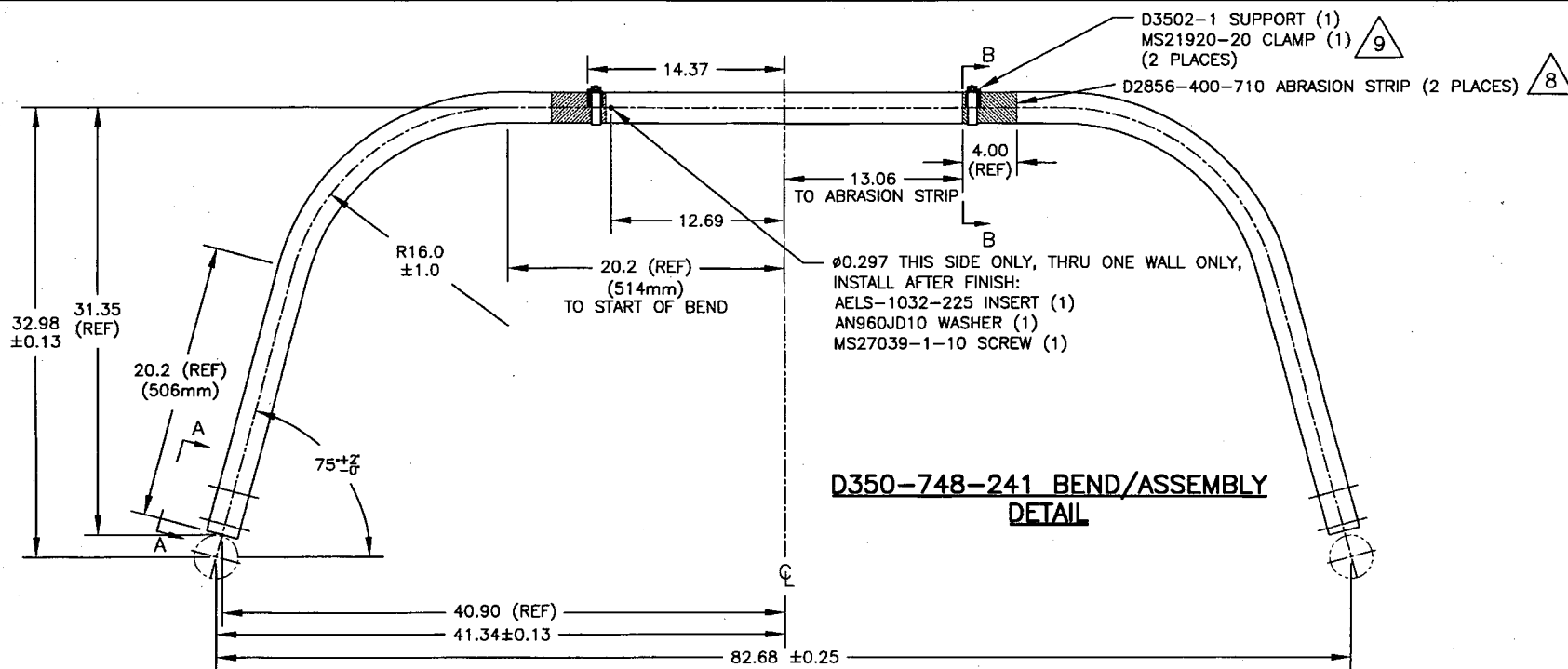
**UNDER REVIEW**

07.02/16 *///*

CUT FILE REDUCED  
07.07.22

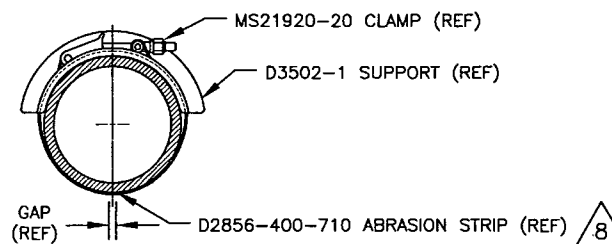
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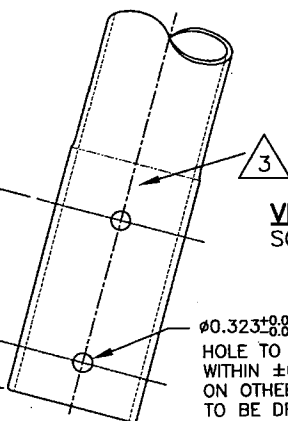
# SECTION B-B

SCALE 1:2



## VIEW A-A

SCALE 1:2



NO. 3582  
WORK ORDER  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY  
003-0.005  
0.780  
0.500

UNDER REVIEW

07.02/16/17  
DART AEROSPACE LTD.  
06.10.31

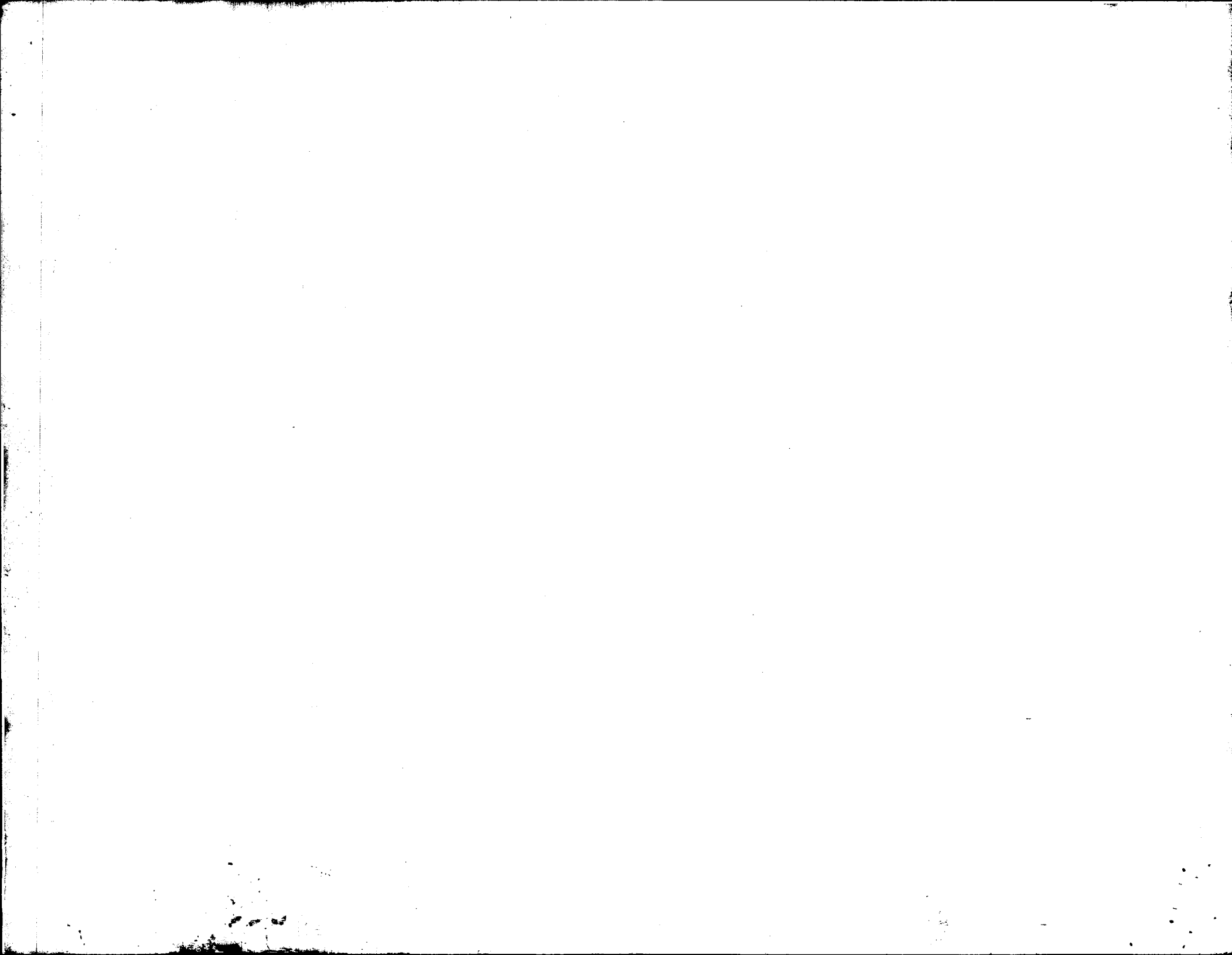
RELEASED

06.10.31

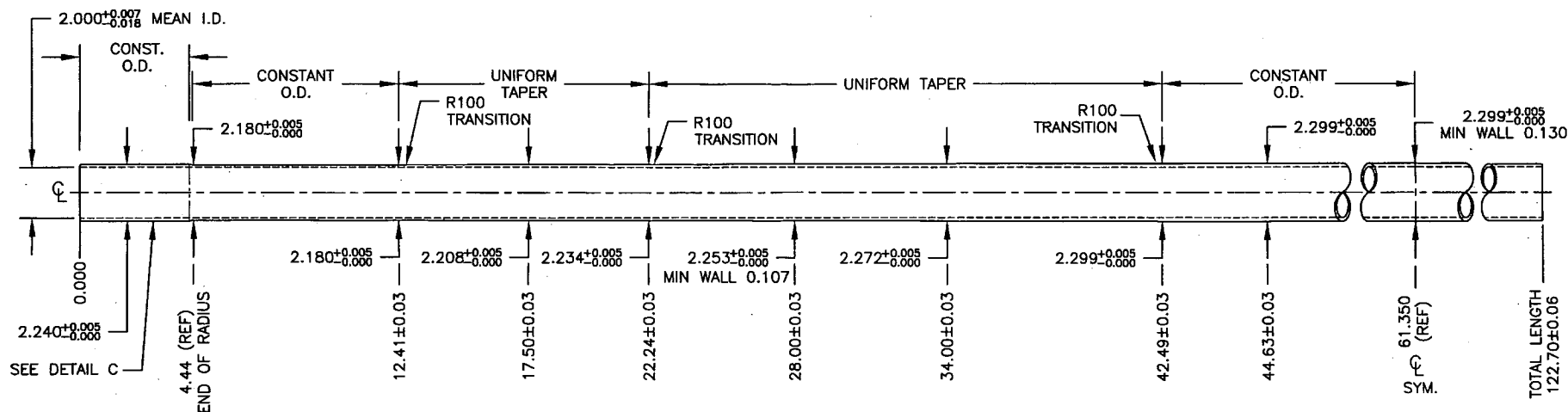
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|                  |  |                             |   |
|------------------|--|-----------------------------|---|
| DESIGN<br>qp     | DRAWN BY<br>qp                         | <b>DART</b>                 | DART AEROSPACE LTD.<br>HAMPSHIRE, ENGLAND, CANADA |
| CHECKED<br>H     | APPROVED<br>H                          | DRAWING NO.<br>D350-748-241 | REV. 0<br>SHEET 2 OF 3                            |
| DATE<br>06.10.31 | TITLE<br>CROSSTUBE (AS 350/355 HI AFT) | SCALE<br>1:8                |   |

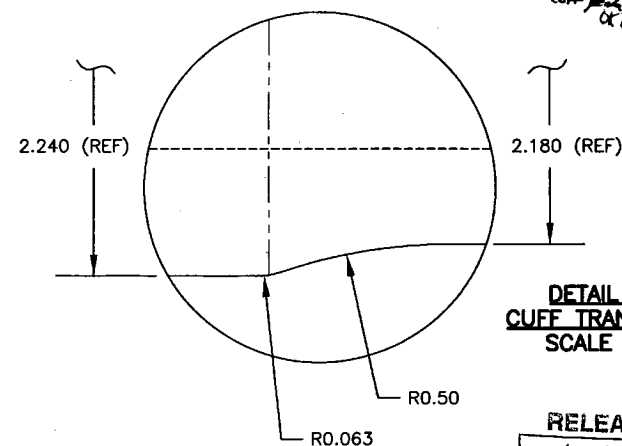
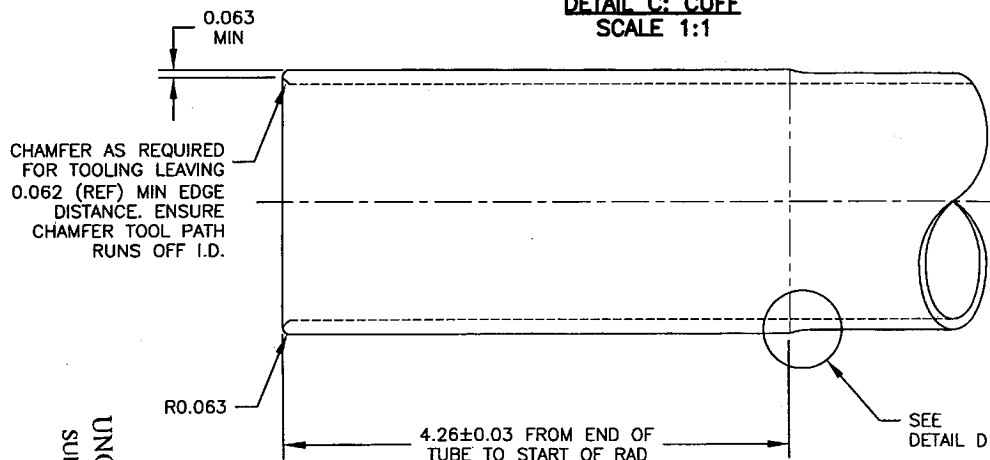






### D350-748-241 MACHINING DETAIL

**DETAIL C: CUFF**  
SCALE 1:1



**DETAIL D:  
CUFF TRANSITION**  
SCALE 9:1

RELEASED

06.10.31

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|         |          |          |                               |                             |   |
|---------|----------|----------|-------------------------------|-----------------------------|---|
| DESIGN  | q7       | DRAWN BY | q7                            | <b>DART</b>                 | DART AEROSPACE LTD.<br>WARRICKSBURY, OXFORD, CANADA |
| CHECKED | #        | APPROVED | #                             | DRAWING NO.<br>D350-748-241 | REV. D<br>SHEET 3 OF 3                              |
| DATE    | 06.10.31 | TITLE    | CROSSTUBE (AS 350/355 HI AFT) | SCALE                       | 1:4   |

NO. 47388  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY  
12/11/06



**CERTIFICATE OF  
CONFORMANCE**

**CADORATH PLATING CO. LTD.  
2150 LOGAN AVENUE  
WINNIPEG, MANITOBA R2J-0J1**

**DATE:** Oct-17-2008

**CONSIGNED TO:** Dart Aerospace Ltd.  
1270 Aberdeen St.  
Hawksbury, ON K6A 1K7

**W/O #:** 80587  
**INVOICE #:** 41382

**CONTRACT OR  
PURCHASE ORDER #** 00007326

**DESCRIPTION:** SKID

**QTY** 1

**P/N #** D350-748-201

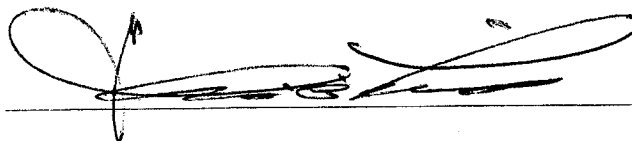
**S/N #** B41398

**MPI IAW ASTM-E-1444. CADMIUM PLATE IAW AMS-QQ-P-416B  
TYPE 2 CLASS 2. BAKE HEAT CHARTS #9725 AND 9741.**

*S*  
*08/10/23*

**CERTIFICATE: I certify that the items indicated here on have  
been inspected and tested and conform to all specifications  
and requirements detailed on the contract or purchase order.**

**Approved Inspector:**



Date: Tuesday, 19/08/2008 11:20:11 AM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 350/355 AS X-TUBE AFT  
 Job Number : 41388  
 Estimate Number : 12486  
 P.O. Number : Part Number : D350748201  
 This Issue : 19/08/2008 S.O. No. : Drawing Number : N/A  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : // Type : CROSSTUBES Drawing Revision : D  
 Previous Run : 40412 Material :  
 Written By : Due Date : 05/09/2008 Qty: 1 Um: Each  
 Checked & Approved By : JUD 08.8.19  
 Comment : Est Rev: A New Issue 06-07-05 JLM  
 Est Rev: B Update qty of MS21042L5 06-09-12 KJ  
 Est Rev C Combined manufacturing 08.04.02 EC verified by:  
 DD  
 Est Rev:D 08-06-24 revD as per dwg DD verified by:EC

REFERENCE ONLY

## Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|     |    |                  |
|-----|----|------------------|
| 1.0 | DC | DOCUMENT CONTROL |
|-----|----|------------------|



JUD 08.8.28



Comment: Photocopy bluefile & type labels per PPPD350-748-201 CHG001

|     |               |                          |
|-----|---------------|--------------------------|
| 2.0 | D350748241TRN | Crosstube Turning Detail |
|-----|---------------|--------------------------|



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)  
 CROSSTUBE TURNING DETAIL  
 batch \_\_\_\_\_

|     |         |                             |
|-----|---------|-----------------------------|
| 3.0 | BENDING | BENDING MACHINE - SKIDTUBES |
|-----|---------|-----------------------------|



Comment: BENDING MACHINE  
 Bend tube as per Dwg D350-748-241 using CNC bender program D350A and Folio FT. \_\_\_\_\_

|     |      |                              |
|-----|------|------------------------------|
| 4.0 | QC15 | DIMENSIONAL CHECK OF X-TUBES |
|-----|------|------------------------------|



Comment: DIMENSIONAL CHECK OF X-TUBES

|     |            |                       |
|-----|------------|-----------------------|
| 5.0 | CROSSTUBES | CROSSTUBES RESOURCE 1 |
|-----|------------|-----------------------|



Comment: LANDING GEAR RESOURCE 1  
 1-Remove all marks from tube within limits of D350-748-241  
 2-Drill Tube as per Dwg D350-748-241 Using DT8876 Drill Jigs,  
 Set-up drill table as per QSI 010

